

Date: Thursday, 9/14/2006 7:27:47 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT BRACKET
Job Number : 28550	
Estimate Number : 10260	
P.O. Number : N/A	Part Number : D23623
This Issue : 9/14/2006 S.O. No. : N/A	Drawing Number : D2362 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : E1
Previous Run : 27765	Material : N/A
Written By : <u> </u>	Due Date : 9/30/2006 Qty: 6 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est: G 00.0518 Added inspection level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2265	Step Support Casting
Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Step Support Pick: Qty Part Number Description Batch 1 D2265 Step Support <u>B25401</u> <u>J.G</u> <u>06/09/29</u> <u>6</u>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: Machine per folio D2362-3 <u>J.G</u> <u>06/09/29</u> <u>6</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: Inspect Level 2 <u>SA</u> <u>06.09.29</u> <u>(6)</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>SA</u> <u>06.09.29</u> <u>6</u>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr <u>J.G</u> <u>06/09/29</u> <u>6</u>		
6.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3 <u>G.M</u> <u>06/10/11</u> <u>(6)</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:27:47 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 28550

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MF. 06/10/11

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

627768

MF. 06/10/11

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

627769

MF. 06/10/11

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement

as per Dwg D2362

Batch

~~M11174~~ M100374

MF. 06/10/12

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 06/10/16

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57173

QB 06/10/17

(6)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/18

Job Completion



u 06/10/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



RELEASED
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
BW	APPROVED	DRAWING NO. D2362	SHEET 1 OF 3
CHECKED KE	DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SCALE 1:2
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
3B BEFORE MANUFACTURE
OK 01/04/04

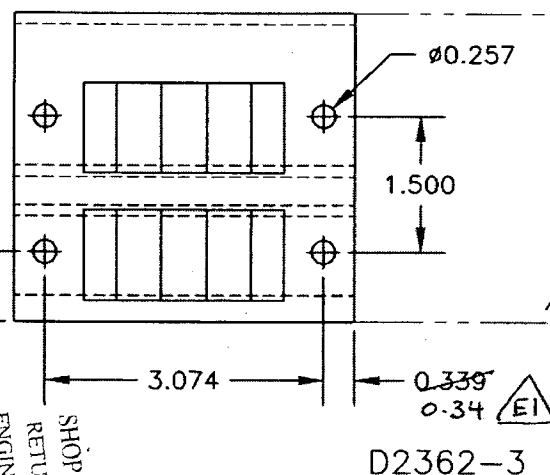
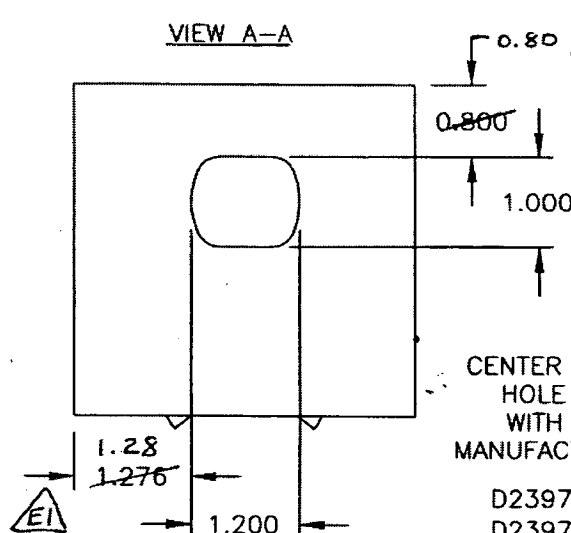
0.257 X 0.75 SLOT

REMOVE TIPS
FROM CASTING
MAX 0.080

CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)

VIEW A-A



0.77
0.767
EI

WORK ORDER
NO. 28550
NOTES:
MAKE FROM D2265
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
SHOP COPY
RETURN TO
ENGINEERING

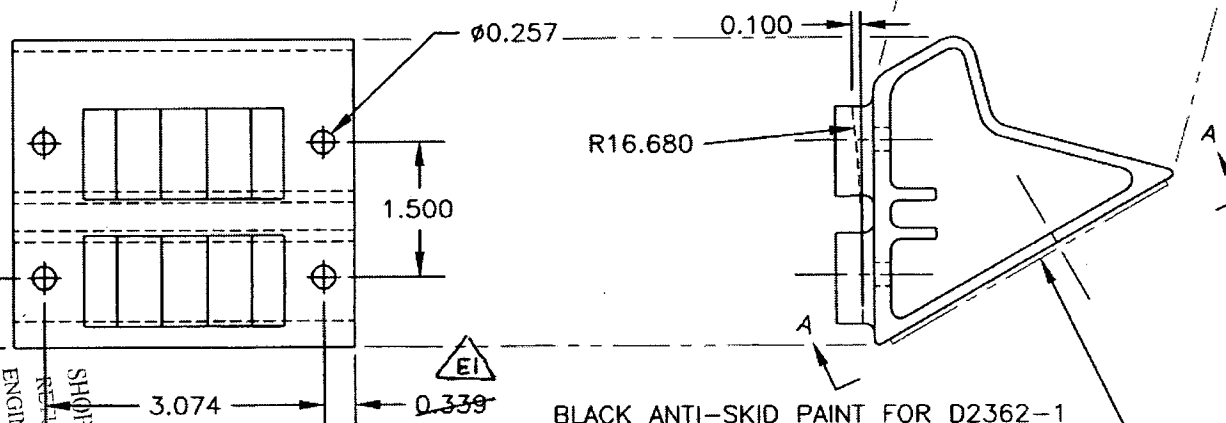
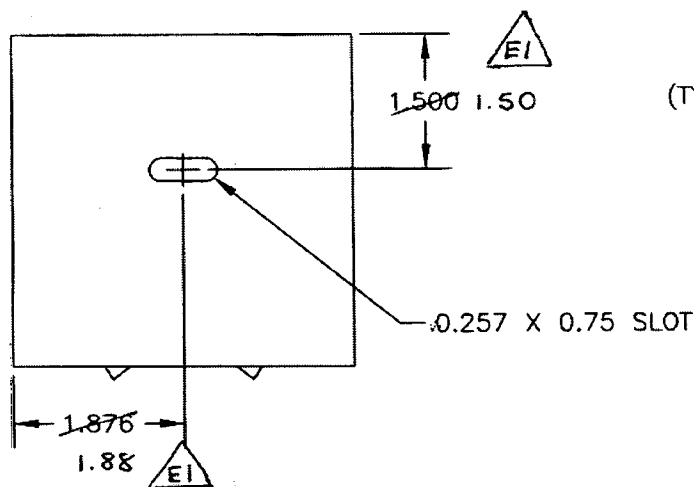


DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED JH	DRAWING NO.
DATE 98.12.04		D2362
	TITLE	STEP SUPPORT BRACKET
	SCALE	1:2
	REV. E	SHEET 2 OF 3

RELEASED
98.12.14
UNDER REVIEW

DESIGNER, BUT CHECK BY
OR BEFORE MANUFACTURE
OK 98.1.05

VIEW A-A



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

NOTE:
MAKE FROM D2265
D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY
NO. 28550



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	<i>CP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E SHEET 3 OF 3 SCALE 1:2

UNDER REVIEW

01/03/15 CP

DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE

RELEASED
98.12.14 KE

D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

